

Work Order ID 66737

Friday, February 25, 2011 11:29:03 AM



Page 1

Item ID: D350-600-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Sliding Door Hinge Installation, LH

Start Date: 2/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 11-02-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D350-600

E

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D350-600-541
CHG001

11 04 12 ⑥
for BG 11-4-4

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/4/14 12

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

8/10/12

⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-600-541

Accept



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Stop



Item Name: Sliding Door Hinge Installation, LH

Start Date: 2/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 		0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-600-541 Location: <u>32</u> PPP rev: <u>A</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

4/4/12 (1)

11/4/13 (1)

LINE !
11-04-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Friday, February 25, 2011 11:29:09 AM

Page 1

Work Order ID: 66737

Parent Item: D350-600-541

Parent Item Name: Sliding Door Hinge Installation, LH

Start Date: 2/25/2011


Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3956-1  Hinge, Airframe Upper		Manufactured	No			110	Each	7.0000	1	1		11/4/48	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	---------	--


Location	Loc Qty	Loc Code
----------	---------	----------


ST104	7	
52922	7	

D3956-3  Hinge, Airframe Lower		Manufactured	No			110	Each	11.0000	1	1		11/4/48	
--	--	--------------	----	--	--	-----	------	---------	---	---	--	---------	--

Location	Loc Qty	Loc Code
----------	---------	----------


ST104	11	
52923	11	

D3957-041  Hinge Assembly, Door LH Upper		Manufactured	No			110	Each	0.0000	1	1		11/4/48	
---	--	--------------	----	--	--	-----	------	--------	---	---	--	---------	--

D3957-043  Hinge Assembly, Door LH Lower		Manufactured	No			110	Each	2.0000	1	1		11/4/48	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	---------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST104	2	
52926	2	

D3816-1  Spacer		Manufactured	No			110	Each	8.0000	2	2		11/4/48	
---	--	--------------	----	--	--	-----	------	--------	---	---	--	---------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST091	8	
45675	8	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 66737

Parent Item: D350-600-541

Parent Item Name: Sliding Door Hinge Installation, LH

Start Date: 2/25/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00



Reinforcement

Manufactured No

110 Each

1.0000

1



11/4/4sf

Location

Loc Qty

Loc Code

ST107

1

52935

1

Manufactured No

110 Each

2.0000

1



11/4/4sf



Reinforcement

Location

Loc Qty

Loc Code

ST107

2

52937

2

Manufactured No

110 Each

40.0000

2



Res to 2 note
B52939 11/4/4sf



Ball Stud

Location

Loc Qty

Loc Code

ST075

40

53951

40

Manufactured No

110 Each

6.0000

1



B66649 11/4/4sf



Door Prop

Location

Loc Qty

Loc Code

ST272

6

65391

6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 66737

Parent Item: D350-600-541

Parent Item Name: Sliding Door Hinge Installation, LH

Start Date: 2/25/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

110

Each

716.0000

3



Bolt



3 11/4/4 SP

Location

Loc Qty

Loc Code

ST350

716

115016

56

115371

500

116632

160

AN3-6A

Purchased

No

110

Each

249.0000

2



Bolt



2 11/4/4 SP

Location

Loc Qty

Loc Code

ST351

249

114941

99

116191

50

116704

100

AN4-17

Purchased

No

110

Each

46.0000

2



BOLT



2 11/4/4 SP

Location

Loc Qty

Loc Code

ST359

46

113121

16

113288

30

AN310-4

Purchased

No

110

Each

46.0000

2



NUT



2 11/4/4 SP

Location

Loc Qty

Loc Code

ST324

46

116786

46

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 66737

Parent Item: D350-600-541

Parent Item Name: Sliding Door Hinge Installation, LH

Start Date: 2/25/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

AN970-4

Purchased

No

110

Each

122.0000

2

12



Washer



11/4/14 sl

Location

Loc Qty

Loc Code

ST344

22

115936

22

ST349

100

116900

100

CR3243-4-3

Purchased

No

110

Each

216.0000

15

15



Rivet



11/4/14 sl

Location

Loc Qty

Loc Code

ST313

216

113064

16

113749

200

CR3243-4-4

Purchased

No

110

Each

207.0000

10

10



RIVET



11/4/14 sl

Location

Loc Qty

Loc Code

ST313

207

104252

207

NAS1149D0363J

Purchased

No

110

Each

2,522.000

11

11



Washer



11/4/14 sl

Location

Loc Qty

Loc Code

ST298

2522

116583

2522

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 66737

Parent Item: D350-600-541

Parent Item Name: Sliding Door Hinge Installation, LH

Start Date: 2/25/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,631.000

11

11



Nut

Location

Loc Qty

Loc Code

ST300

2631

114784

9

115835

122

116391

900

116540

800

116549

800

MS24665-2-12

Purchased

No

110

Each

69.0000

2

2



COTTER PIN

Location

Loc Qty

Loc Code

ST309

69

111499

69

MS24693-S274

Purchased

No

110

Each

41.0000

4

4



Screw

Location

Loc Qty

Loc Code

ST288

41

114718

41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

-541	-542	Part Number	Description
X		D350-600-541	LH SLIDING DOOR HINGE KIT
X	X	D350-600-542	RH SLIDING DOOR HINGE KIT
1	1	D3956-1	HINGE, AIRFRAME UPPER
1	1	D3956-3	HINGE, AIRFRAME LOWER
1		D3957-041	HINGE ASSEMBLY, LH DOOR UPPER
	1	D3957-042	HINGE ASSEMBLY, RH DOOR UPPER
1		D3957-043	HINGE ASSEMBLY, LH DOOR LOWER
	1	D3957-044	HINGE ASSEMBLY, RH DOOR LOWER
2*	2*	D3815-3	ROD END
2	2	D3816-1	SPACER
4	4	D3816-3	SPACER
1	1	D3968-1	BACKING PLATE
1	1	D3968-3	BACKING PLATE
1	1	D3991-1	PACKER
1	1	D3991-3	PACKER
1		D3992-1	REINFORCEMENT
	1	D3992-2	REINFORCEMENT
1		D3992-3	REINFORCEMENT
	1	D3992-4	REINFORCEMENT
2	2	D3622-3	BALL STUD
1	1	D3552-11	GAS SPRING
3	3	AN3-5A	BOLT
2	2	AN3-6A	BOLT
2	2	AN4-17	BOLT
2	2	AN310-4	CASTLE NUT
2	2	AN970-4	WASHER
15	15	CR3243-4-3	CHERRY MAX RIVET
10	10	CR3243-4-4	CHERRY MAX RIVET
11	11	NAS1149D0363J	WASHER
2*	2*	NAS509-6	NUT
11	11	MS21042L3	NUT
2	2	MS24665-212	COTTER PIN
4	4	MS24693S274	SCREW

* Pre-installed on D3957-041/-042/-043/-044 Hinge Assemblies

